

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013841**Date Inspected:** 01-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

8BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at CA052 cross beam side of segment. Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located at CA051 bike path side of segment. Welder is identified as Mr. Hu Yanming (062092). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

8AE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 001 located at CA048 bike path side of segment. Welder is identified as Mr. Zhao Aifei (067942). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-4G

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(4F)-FCM-Repair-1 and WR12548 repair procedure.

8CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 129 and 133 located at SSD27-PP069 cross beam side of segment. Welder is identified as Mr. Wang Quanlin (066746). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2132.

7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 013~018 located at DP640-001 counter weight side of segment. Welder is identified as Mr. Luo Xuanping (067610). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-4114-1.

7DW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 023 and 024 located at SP441-001 cross beam side of segment. Welder is identified as Mr. Zang Wai (066413). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at SEG039A cross beam side of segment. Welder is identified as Mr. Zang Wai (066413). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and WR12294 repair procedure.

7DW+7EW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 020~030 located at BP146-001 bottom plate of segment. Welder is identified as Mr. Xu Changxue (066002). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-B-U2a-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 020~030 located at BP038-001 bottom plate of segment. Welder is identified as Mr. Dong Youcun (067588). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-B-U2a-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 006 located at OBW7C counter weight side of segment. Welder is identified as Mr. Cao Xinglong (069683). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2114-B-U2a-FCM-1.

7BW

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Shield Metal Arc Welding (SMAW) welding was performed on weld joint 177, 176, 167 and 168 located at SEG035D cross beam side of segment. Welder is identified as Mr. Hue Junrong (201215). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 043, 044, 016 and 017 located at SEG035E cross beam side of segment. Welder is identified as Mrs. Li Xianyou (047866). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

7BE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 170 located at SSD16-PP050 cross beam side of segment. Welder is identified as Mr. Bi Shijian (068761). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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